

Date: Thursday, 18/09/2008 11:13:08 AM  
 User: Julie Lecocq

## Process Sheet

|                       |  |                  |                               |
|-----------------------|--|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : DOOR ASSEMBLY               |
| Job Number            | : 42104  |                  |                               |
| Estimate Number       | : 10711  |                  |                               |
| P.O. Number           | :  | Part Number      | : D32131                      |
| This Issue            | : 18/09/2008 S.O. No. :  | Drawing Number   | : D3213 REV A                 |
| Prsht Rev.            | : NC   | Project Number   | : N/A                         |
| First Issue           | : 11 Type : SMALL /MED FAB   | Drawing Revision | : A                           |
| Previous Run          | : 38834  | Material         | : L                           |
| Written By            | :  | Due Date         | : 30/09/2008 Qty: 16 Um: Each |
| Checked & Approved By | : <u>JUD 08.9.18</u>   |                  |                               |
| Comment               | : Est Rev:A New Issue 05-11-17 JLM<br>Est Rev:B Now on Waterjet 07-02-13 JLM |                  |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.4950 sf(s)/Unit Total : 7.9195 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
 (M2024T3S.063) Identify as D3213-1  
 Batch: 109463

P/2

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



A  
A

1B 8-10-23



20  
16

Comment: FLOW WATER JET

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



1B 8-10-23



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 08/10/23 (+16)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

1B 8-10-23

|     |                 |                            |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



16x

Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

M-1 08/10/27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3213-1 PAR #: N/A Fault Category: Prod Engineering <sup>Coord. noted</sup> NCR: (Yes) No DQA: 12 Date: 08/11/09  
D350-567-031 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12 Date: 08/11/04

| NCR: 42104 |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |  |                               |                           |                       |                          |
|------------|------|--|-----------------------------|--|-------------------------------|---------------------------|-----------------------|--------------------------|
| DATE       | STEP | Description of NC<br>Section A   | Corrective Action Section B |  |                               | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|            |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date                |                           |                       |                          |
| 08/10/23   | 2.0  | on 4 parts there are four (4) holes about 0.138" in Dia. supposed to be 0.128" 0.010" above nominal. | <i>[Signature]</i>          | fix water Jet Program<br>Inspect the orifice diameter.<br>Scrap 4 & no replace | <i>[Signature]</i><br>8-10-28 | <i>[Signature]</i>        | <i>[Signature]</i>    | <i>[Signature]</i>       |
|            |      | RC Program error   |                             |  |                               |                           |                       |                          |
|            |      |  |                             |  |                               |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:13:08 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 42104

Part Number: D32131

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*Handwritten signature*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-10-22*

*(X16)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



*16x*

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *180*

*8/10/27*

*50*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/10/27*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.10.28*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

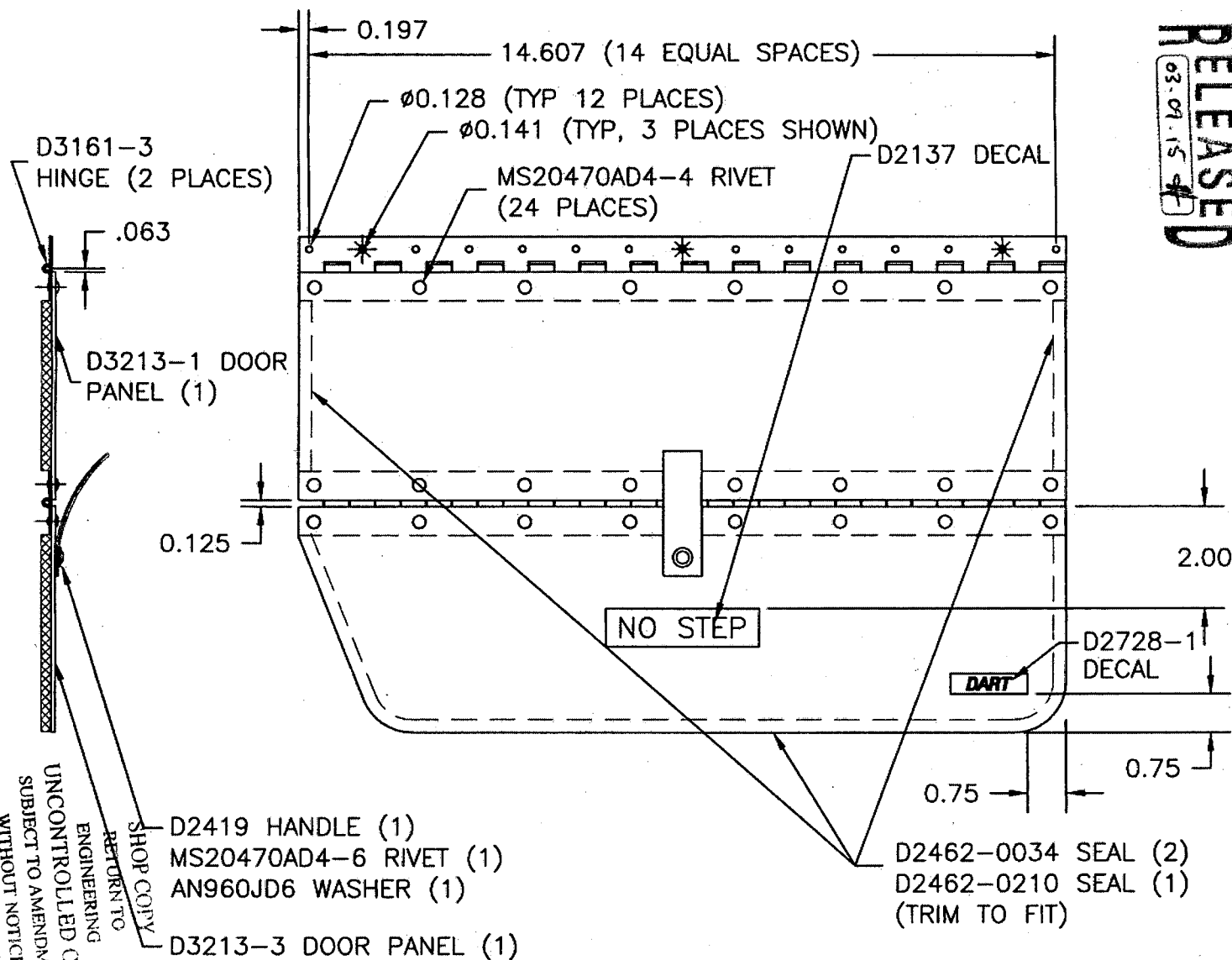


**DART**



| DESIGN                     | DRAWN BY                    | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|----------------------------|-----------------------------|---|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3213                                 |
| DATE 03.09.03              | 03.09.03                    | TITLE DOOR ASSEMBLY                               |
| A                          | NEW ISSUE                   | REV. A<br>1 OF 2<br>SCALE 1:3                     |

RELEASED  
03.09.15



**D3213-041 DOOR ASSEMBLY**

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

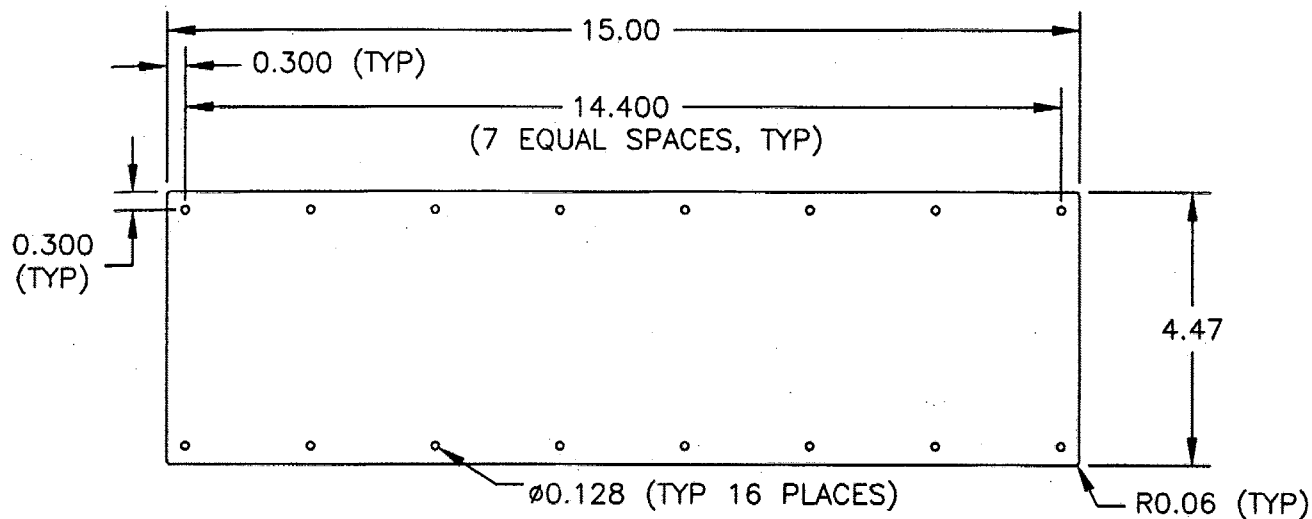
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

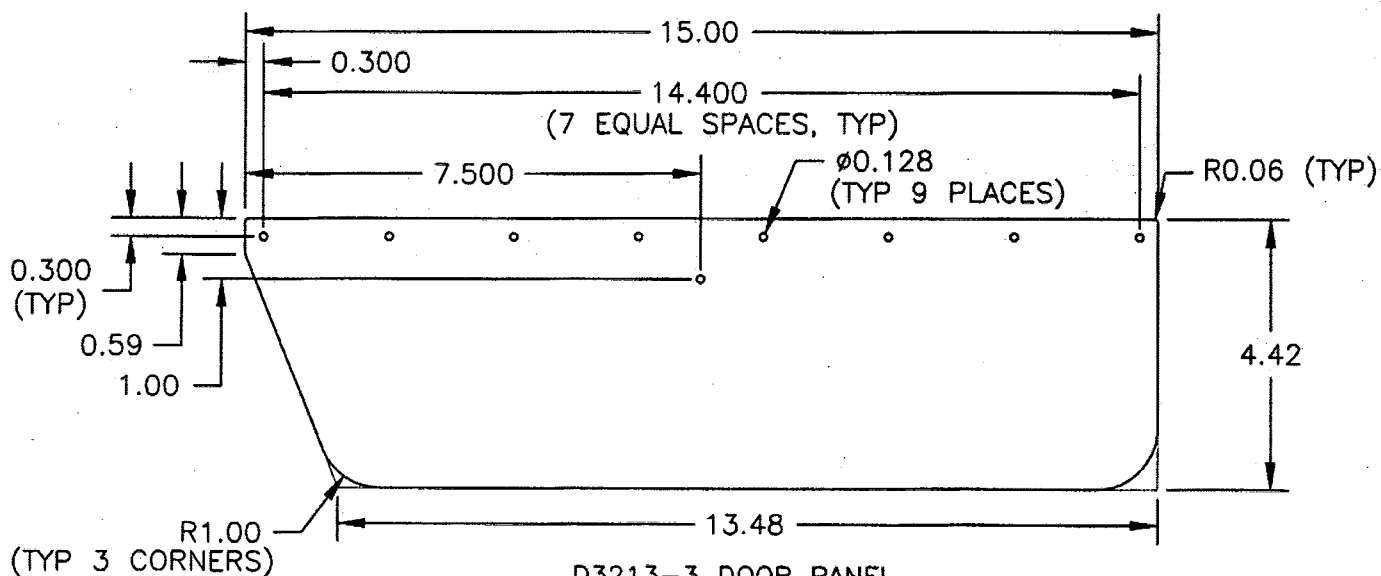
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



|                        |                         |   |                  |
|------------------------|-------------------------|---|------------------|
| DESIGN<br>CP           | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                  |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3213                              | REV. A<br>2 OF 2 |
| DATE<br>03.09.03       |                         | TITLE<br>DOOR ASSEMBLY                            | SCALE<br>1:3     |



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

03.09.15

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NO. 62104

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